

Date: Monday, 2/19/2007 8:07:41 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 30749		
Estimate Number	: 11041		
P.O. Number	: N/A	Part Number	: D2809
This Issue	: 2/19/2007 S.O. No. : N/A	Drawing Number	: D2809 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 28645	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 2/26/2007
Checked & Approved By	: <u>JA 02.02.19</u>	Qty:	50 Um: Each
Comment	: Est C 02.03.07 Now turned in house NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0500	6061-T6 Round Bar .500"
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Comment: Qty.: 0.1045 f(s)/Unit Total : 5.2238 f(s)  
 6061-T6 Round Bar .500"  
 Material: 6061-T6 (QQ-A-250-11) rod .500"Ø

Batch: M102447JF 07/02/20

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL  
 Machine as per Folio FA204

JF 07/02/20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 07/02/22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 07/02/22

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Tumble & deburr all sharp edges as per dwg

SP 07/02/22

20  
 68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes NO DQA: 1 Date: 07/02/28

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 30749

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*YL* 07/02/26 x 68

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

*m/03/4/*

*FL/M-B* 07/02/26 (68)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *J*

*P 7/2/28* (68)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(68)

Comment: FINAL INSPECTION/W/O RELEASE

*07/02/28*

Job Completion



*U 07/02/28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

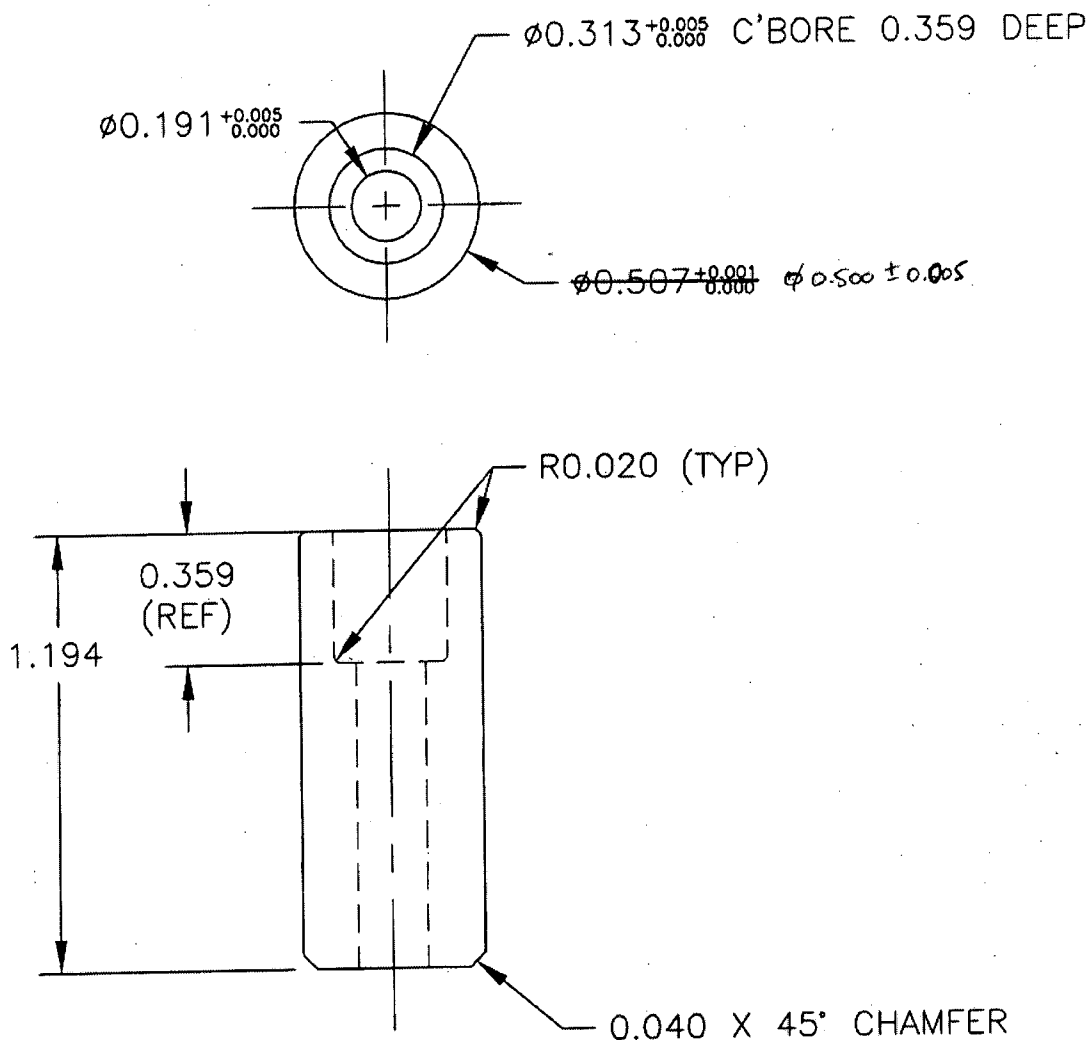
NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	<i>[Signature]</i> 01.04.26	ADD POWDER COAT; $\phi 0.500$ WKS $\phi 0.507$	

RELEASED  
00.11.13 *[Signature]*



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020  
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30749

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PER DART QSI 005 4.3